

Wednesday, 2/20/2008 4:21:09 PM  
Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R/H LOW PROFILE BASKET BASE ASS'Y
Job Number : 37525	
Estimate Number : 13171	
P.O. Number :	Part Number : D3712042
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D3712 U/R
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : U/R
Previous Run : 37524	Material :
Written By : <u>W</u>	Due Date : 3/10/2008 Qty: 1 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est Rev:A new issue 08-01-30 DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s)  
304 SQ Tube.75x.75x.065W

*JJ 08/02/25*

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3726-1	<u>M107038</u>
2	D3727-1	<u>M107038</u>
2	D3734-1	<u>M107038</u>
6	D3735-1	<u>M107038</u>
3	D3739-1	<u>M107038</u>
3	D3740-1	<u>M107038</u>
ASS 21	D3759-1	<u>B371663</u>

2- deburr

*PL 08-03-07*

2.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spacer Bushing  
batch B36479

*PL 08-02-27*

3.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Mounting Bracket  
batch B36481

*PL 08-02-27*

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A		Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:21:09 PM

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Drawing Name: R/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37525

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch

B37127

Pl 08-02-27

5.0

D37481

HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch

B37305

Pl 08-02-27

6.0

D31661

Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Batch:

B36752

Pl 08/02/25

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Pl 08/02/25

1- take D3166-1 and trim as per dwg D3746 to make D3746-1

2- take D3746-1 and drill holes as per dwg D3646

3- drill holes in both D3727-1 as per dwg D3727

4- take 1x D3735-1 and drill holes as per dwg D3735

5- deburr

6- assemble as per dwg D3712 and weld as per QSI004

Pl 08-02-27

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08-02-27

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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## Process Sheet

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Drawing Name: R/H LOW PROFILE BASKET BASE ASS'Y

Job Number: 37525

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



ASS  
08.02.27



Comment: INSPECT WORK TO CURRENT STEP

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.9000 sf(s)/Unit Total : 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number Description Batch  
38sq.ft M304EX0.75-16F Expanded Metal

Batch  
M106884

08.02.27

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D

2- weld mesh as per dwg D3712

08.02.27  
08.03.03

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

ASS 08.03.10 / 08.03.10

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08.03.07

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M102005

08/03/10

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-12

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

08-03-02

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number: 37525

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*2008/3/13*

①

POSITIVE RECALL

EFFECTIVE 01/12/11 AUTH h

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

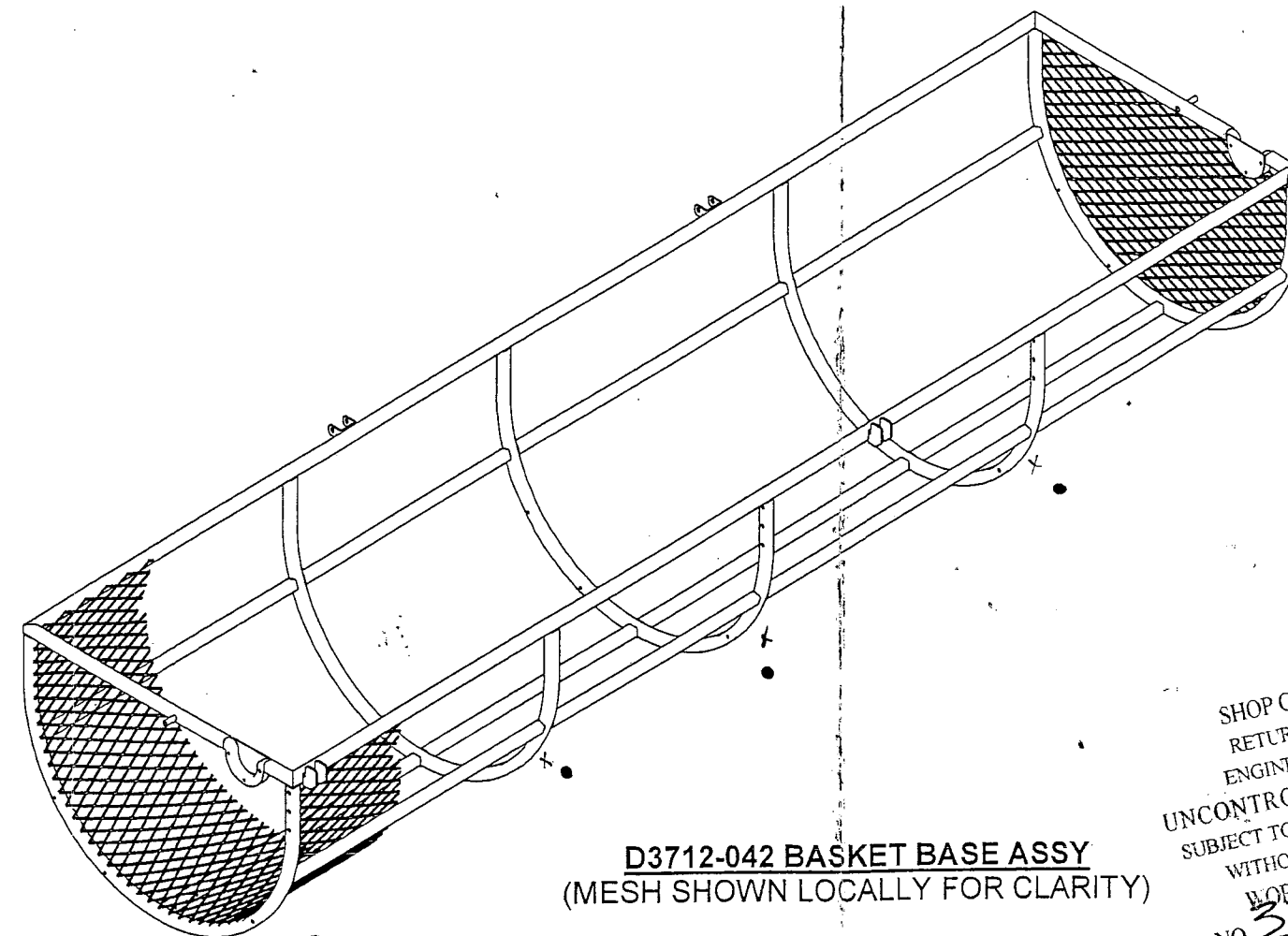
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A		Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY. -041	PART NUMBER	DESCRIPTION
X	D3712-042	BASKET BASE ASSY
2	D2327-3	SPACER BUSHING
2	D2581	MOUNTING BRACKET
2	D3725-1	HOOP
2	D3726-1	RIB
2	D3727-1	RIB
2	D3734-1	RIB
5	D3735-1	RIB
1	D3735-3	RIB
3	D3739-1	RIB
3	D3740-1	RIB
1	D3744-1	MESH
1	D3745-1	MESH
1	D3745-3	MESH
1	D3746-1	RIB
1	D3746-3	RIB
2	D3746-5	RIB
1	D3746-7	RIB
3	D3748-1	HINGE HALF
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT



**D3712-042 BASKET BASE ASSY**  
(MESH SHOWN LOCALLY FOR CLARITY)

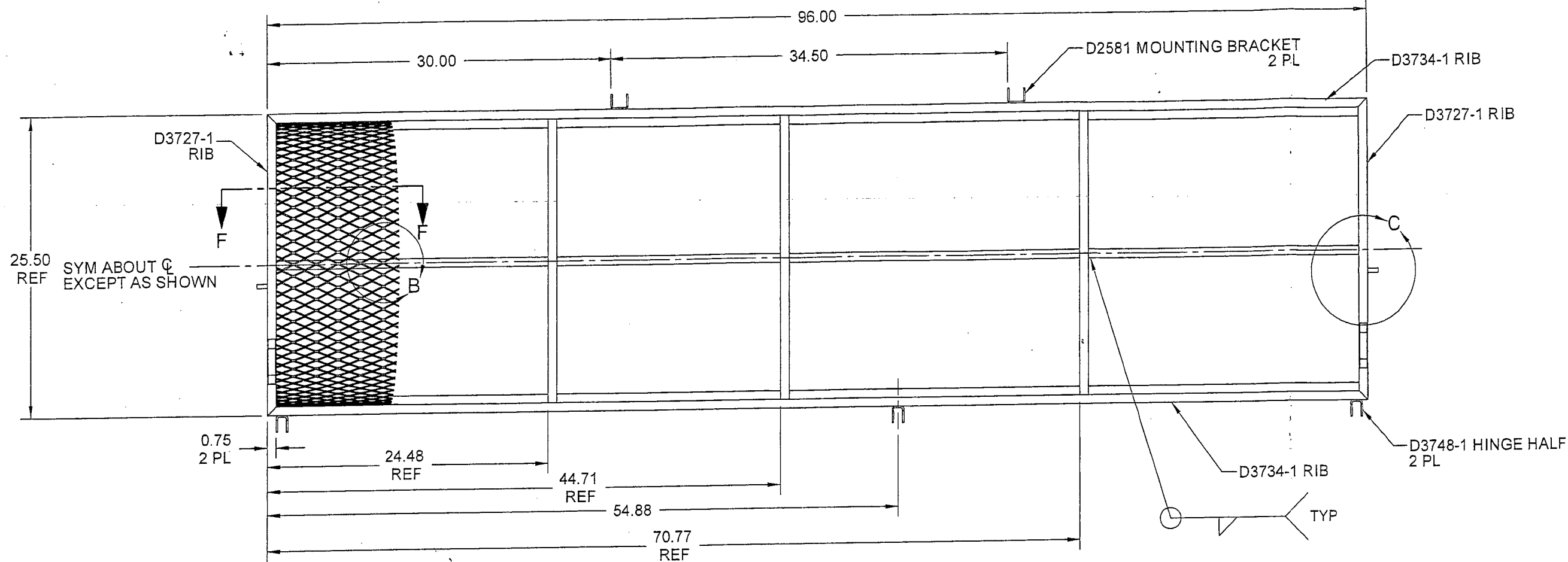
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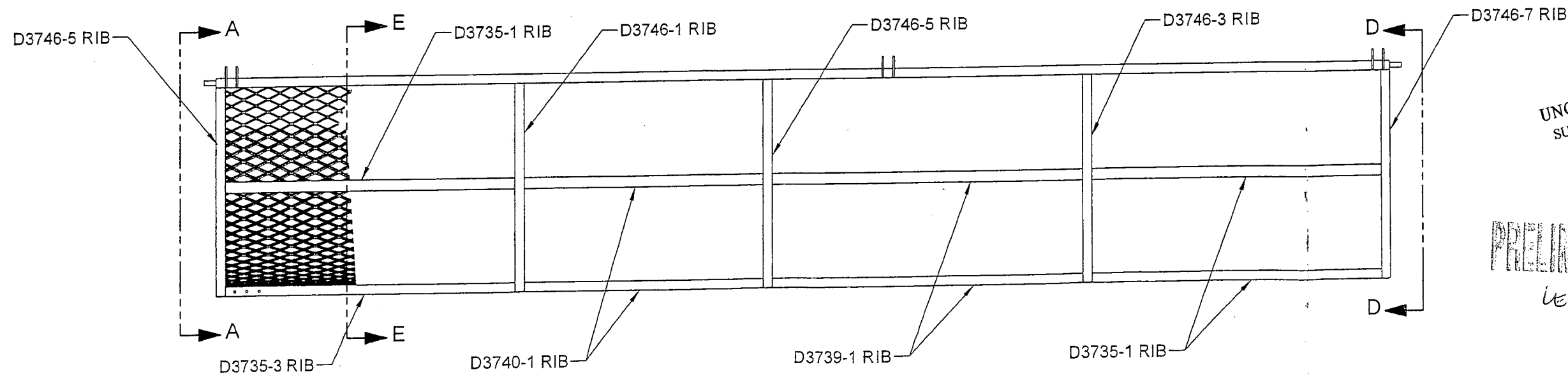
LE 08.02.15

- NOTES:
- 1) MATERIAL: NONE
  - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 41.53 lbs
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.		D3712	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.	LE	BASKET BASE ASSY	NTS
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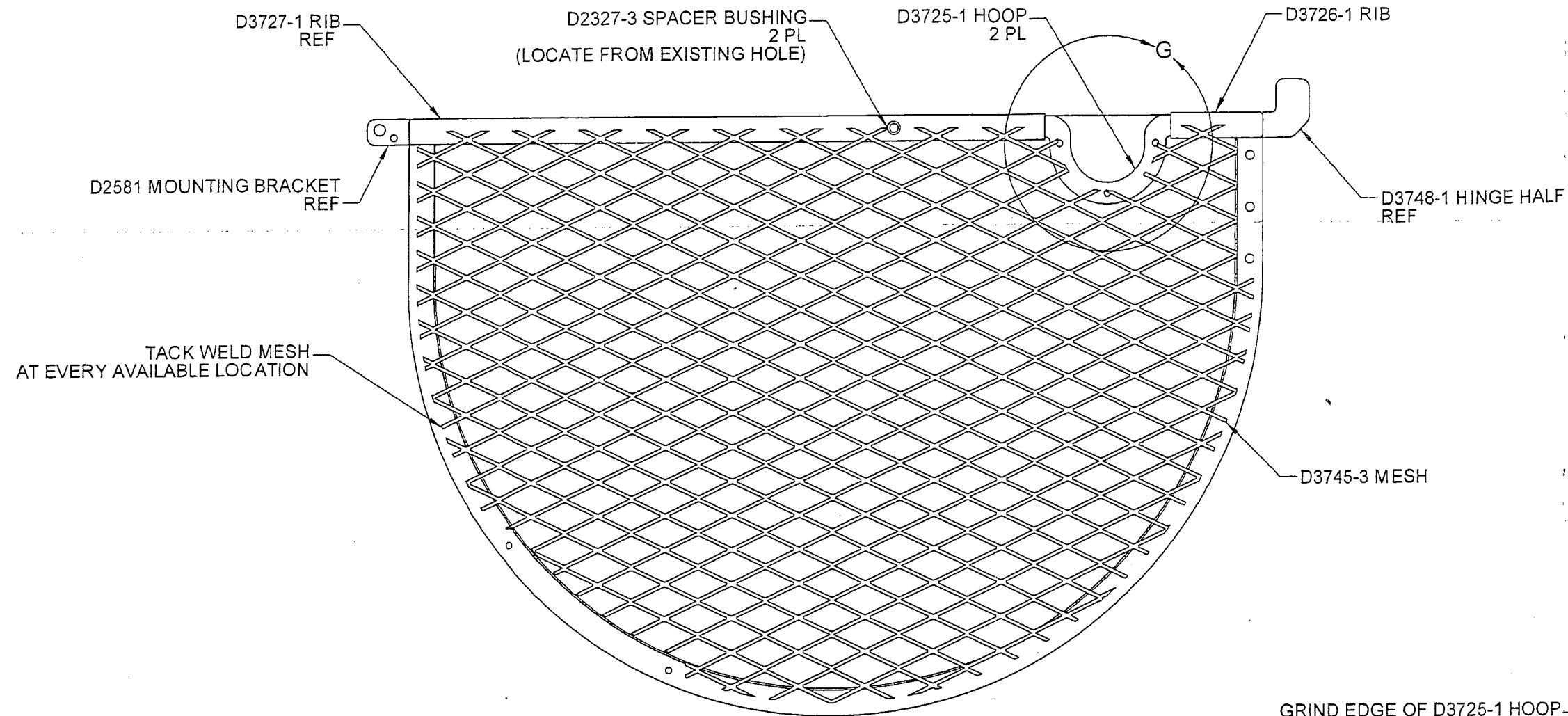
**D3712-041 BASKET BASE ASSY**

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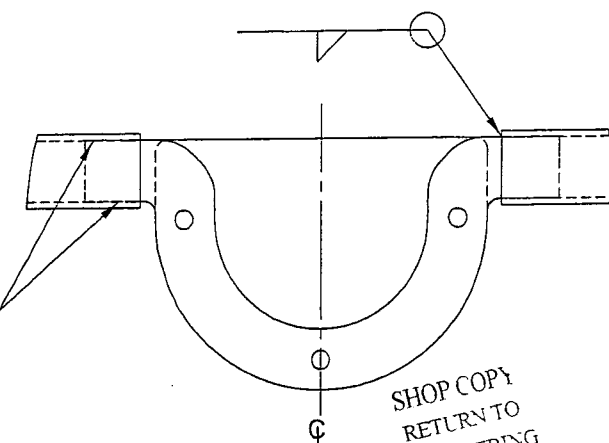
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DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	U	DRAWING NO.	REV. A
MFG. APPR.		D3712	SHEET 2 OF 4
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SECTION A-A  
SCALE 1:4

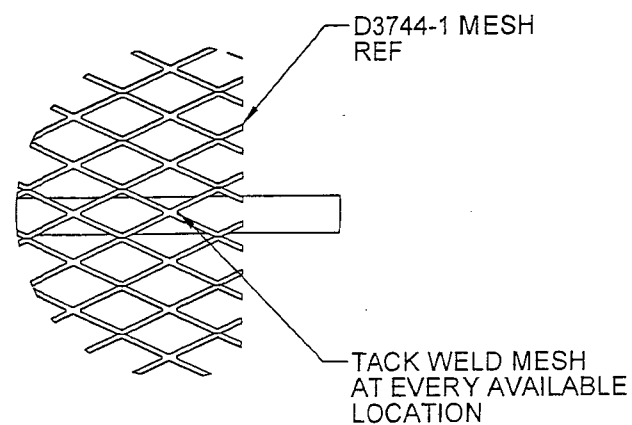
GRIND EDGE OF D3725-1 HOOP  
LOCALLY AS REQUIRED  
ON ASSEMBLY



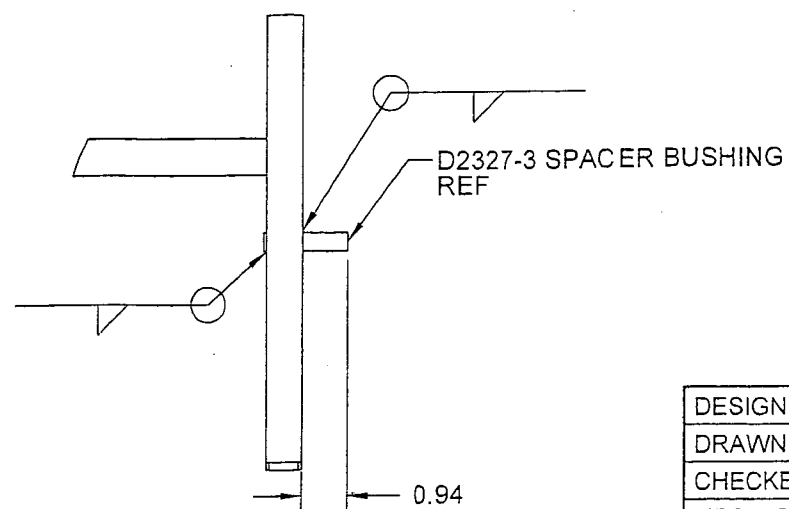
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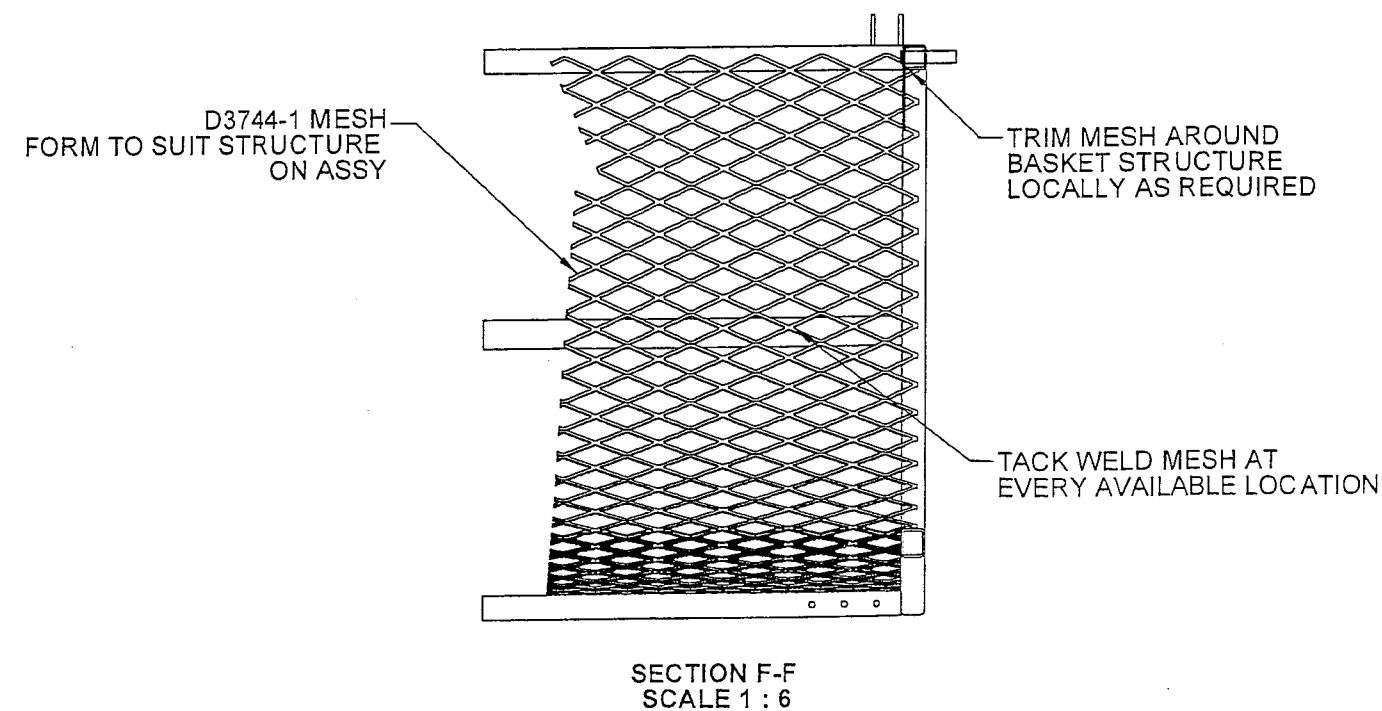
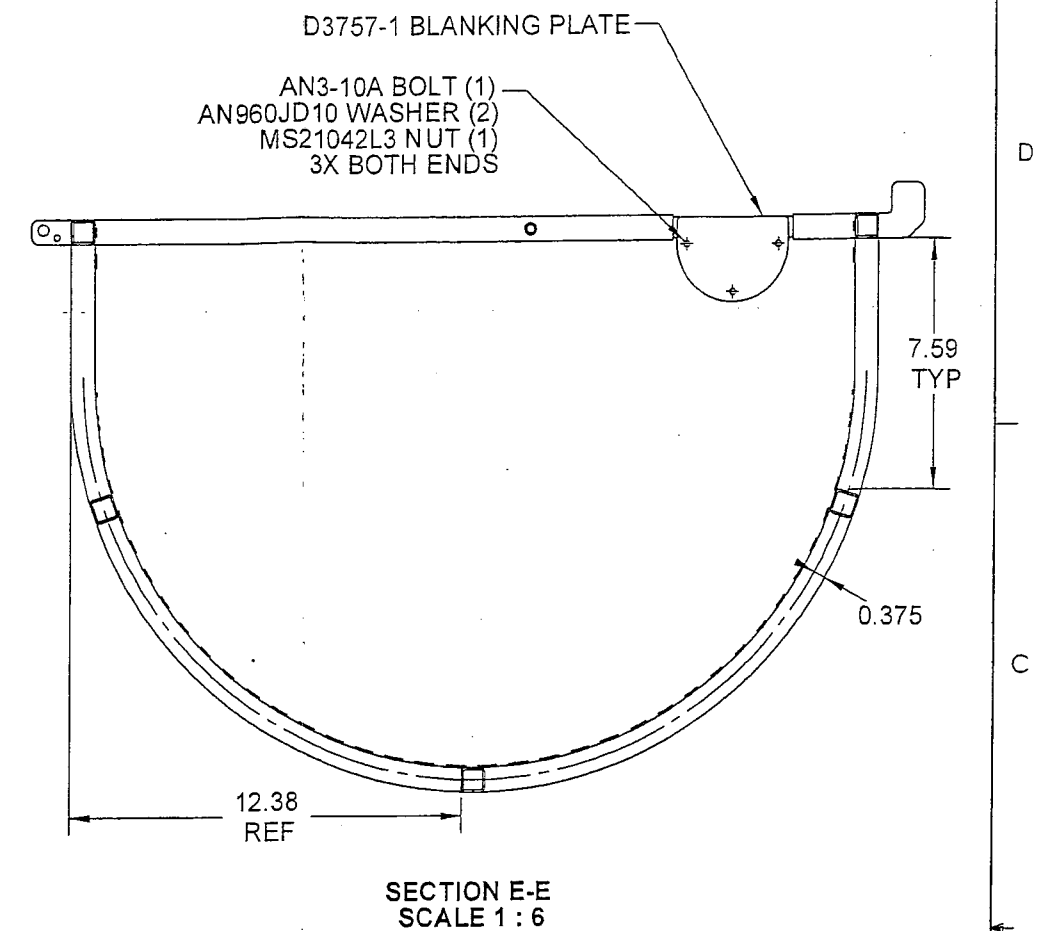
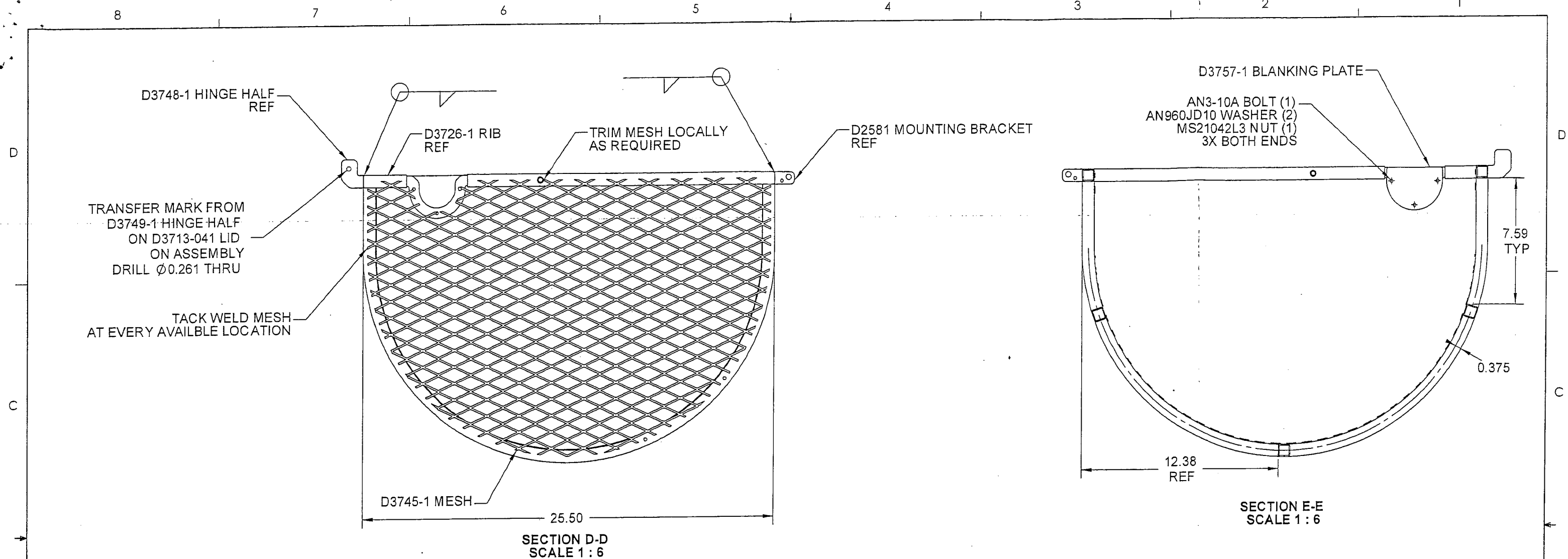


DETAIL B  
SCALE 1:4



DETAIL C  
SCALE 1:4

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08.02.15

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MFG. APPR.			SHEET 4 OF 4
APPROVED	1	TITLE	SCALE
DE APPR.	UE	BASKET BASE ASSY	1:6
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